

Date: Friday, 01/08/2008 3:32:28 PM
 User: Julie Lecocq

Process Sheet

ASAP

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FRONT OUTBOARD LEG (RH)
Job Number	: 40974		
Estimate Number	: 13377		
P.O. Number	:	Part Number	: D37684
This Issue	: 01/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3768 REVA
First Issue	: / /	Project Number	: N/A
Previous Run	: 40712	Drawing Revision	: A
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 21/08/2008
Checked & Approved By	: <u>Jul 08.8.05</u>	Qty:	10 Um: Each
Comment	: Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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Comment: Qty.: 0.8969 f(s)/Unit Total : 8.9691 f(s)

6061T6 TUBE (1.00" x 0.65" wall)

batch: M104819 2.983'

10B340 x 3.416'
107950 x 1.708'
2.562'

RQ 08/08/06

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan Lathe

1- Turn as per Folio FA758 Rev: A & Dwg D3768 Rev: A

2-Deburr per dwg D3768

RQ 08/08/06

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RQ 08/08/06 (10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

IL 08/08/06

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AL 08-08-06 (X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:32:28 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT OUTBOARD LEG (RH)

Job Number: 40974

Part Number: D37684

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M18052



(10X)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30
320°C
11:00

M-d 08/08/07

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-07

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(10X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 118

8/8/7

36

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

08/08/08

Job Completion



MF 08-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

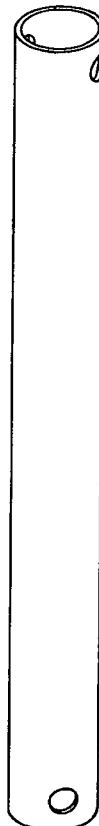
D

C

C

B

B



D3768-1 FRONT INBOARD LEG

D3768-3 FRONT OUTBOARD LEG, LH

D3768-4 FRONT OUTBOARD LEG, RH

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08-06-16

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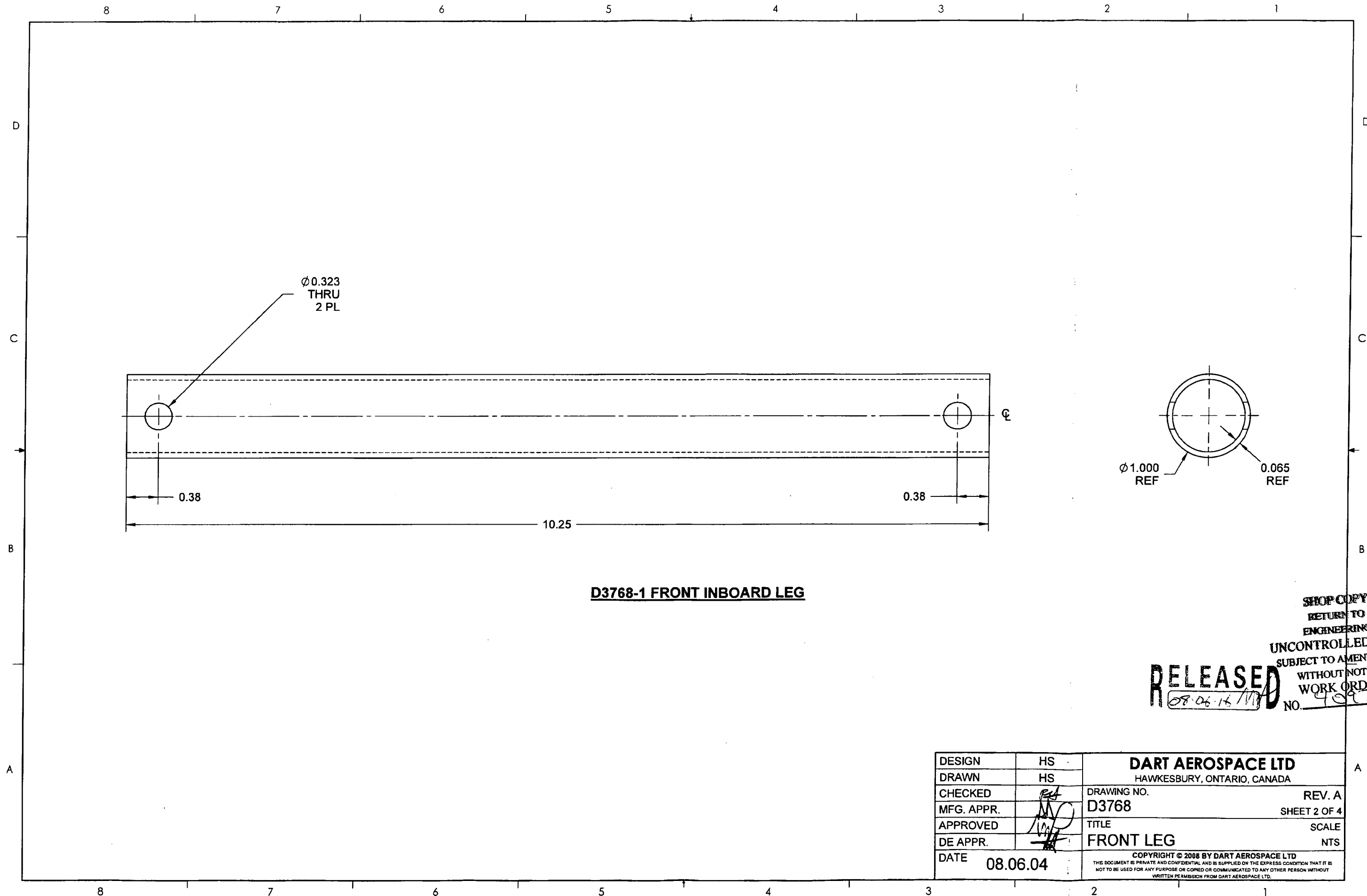
A

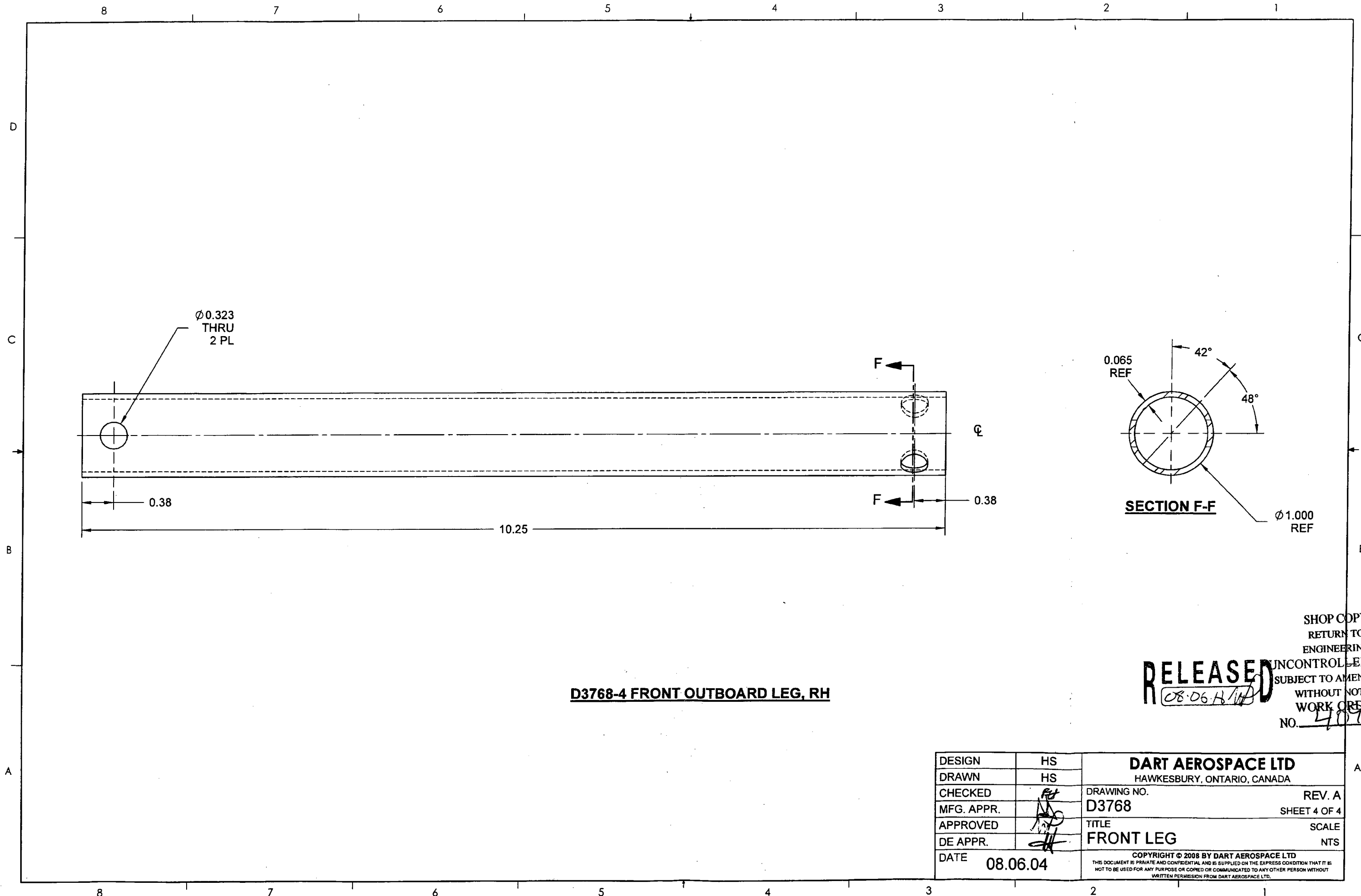
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NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.19 lbs

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
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8 7 6 5 4 3 2 1





D3768-4 FRONT OUTBOARD LEG, RH

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08.06.04

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